

Work Order ID 80730

February-28-12 10:33:02 AM

80730

Page 1

Item ID: D3319-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 28/02/2012 Start Qty: 10.00

10

Required Date: 13/03/2012 Req'd Qty: 10.00

10

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *FAI*

Date: *28/2/12*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319

Dwg Rev: *1*

Prog Rev: *1*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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N9000040100

Revision ID:

Setup Start

Item Name: Wearplate

NS1

Start Date: 28/02/2012 Start Qty: 10.00

Stop *NS2*

Required Date: 13/03/2012 Req'd Qty: 10.00

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

140

140

Brake NC

Brake NC

NC BRAKE

Memo

0.00

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: 12/03/09
2- Form flat on press using DT8776 block

150

150

QC

Quality Control

QC'6- Inspect dimensions to drawing

0.00

Memo

0.00

160

160

Large Fab

Large Fab

Weld per dwg A/R Hardcoat steel Batch: 119712 0.00
Large Fab

Memo

0.00

1- Layout weld location as per Dwg D3319 using jig D3319-1T3
2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: B
Qty Part Number Description Batch
A/R N/A 228/7560 Hardcoat Rod 119712

EL/22. 10-3-7 (42)

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Page 3

Item ID: D3319-1

Revision ID:

Item Name: Wearplate

Start Date: 28/02/2012 Start Qty: 10.00

Required Date: 13/03/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	insp. Stamp
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170

QC 10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

8/13/07

Quality Control

180

QC 5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

8/13/07

Quality Control

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:00

320

3:30

0.00

0 F

2X8 m/f 12/03/07

m118489

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

Item ID: D3319-1

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 28/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

200

QC3-Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

2 of 4 12/03/07

210

0.00

210

Packaging

Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX
For Product Eligibility see PDA05-18 and Stock
Location _____

12/3/7 v. JRC

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLC 12/03/08

mf 12-03-07

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Picklist Print

February-28-12 10:33:06 AM

Page 1

Work Order ID: 80730

80730

Parent Item: D3319-1

D3319-1

Parent Item Name: Wearplate

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B05.10.14 Added step 9, dwg rev B KJEC
IPP Rev: C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	SF	204.8000	0.628	6.610526			
**													

M1010S18GA

1010/1025 SHUFF 038

Location

Loc Qty

Loc Code

MAT019

204.8

116268

10

117806

194.8

116268

117806

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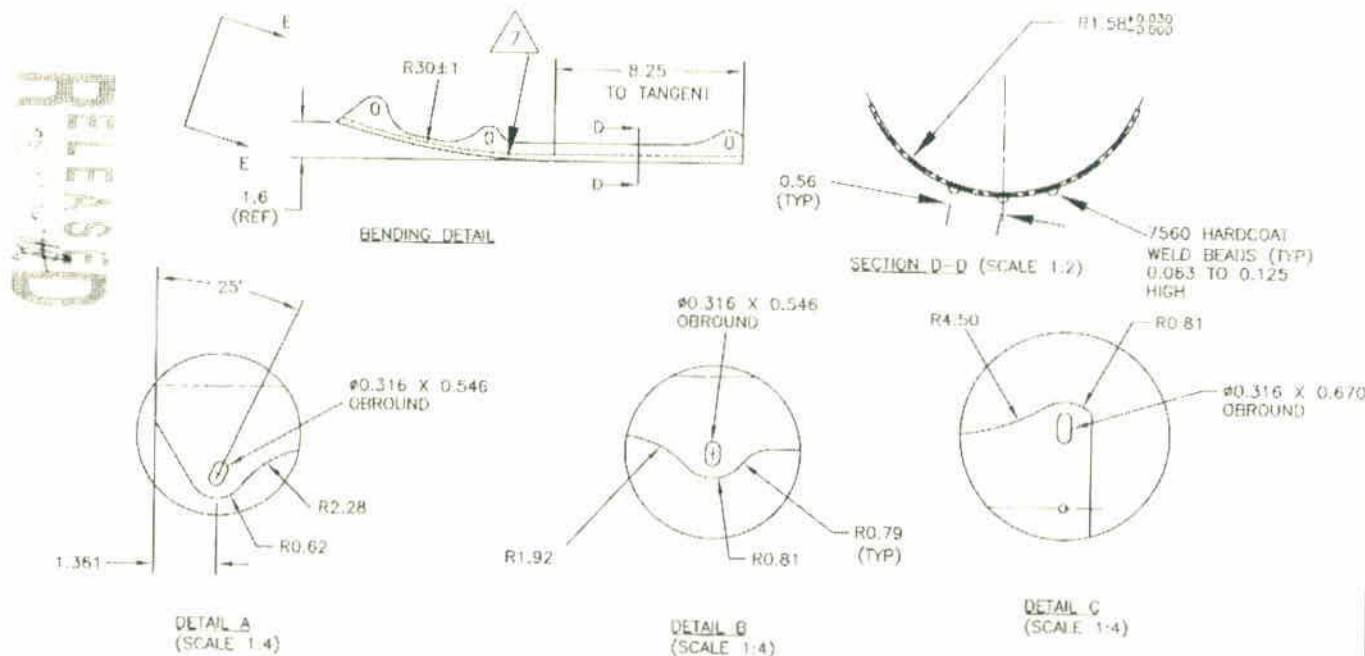
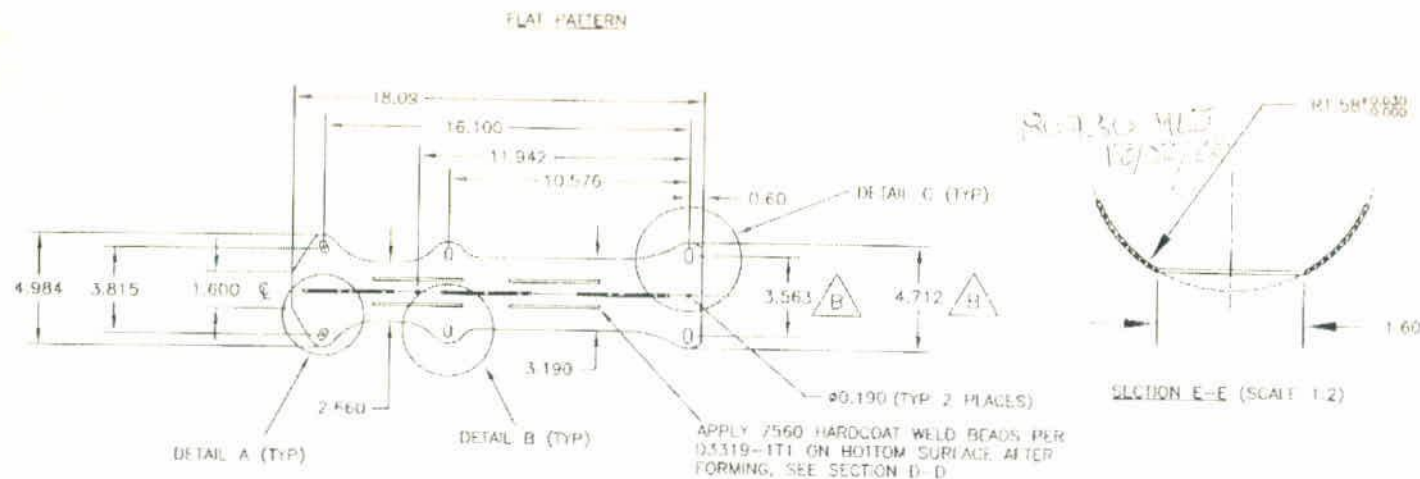
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDING (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	P1	HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.06.06	04.09.24	D3319
DATE	TITLE	WEARPLATE
05.06.06	NEW ISSUE	SCALE
B	WIDEN HOLES, REDUCE WIDTH -3/-5/-7	1:8

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

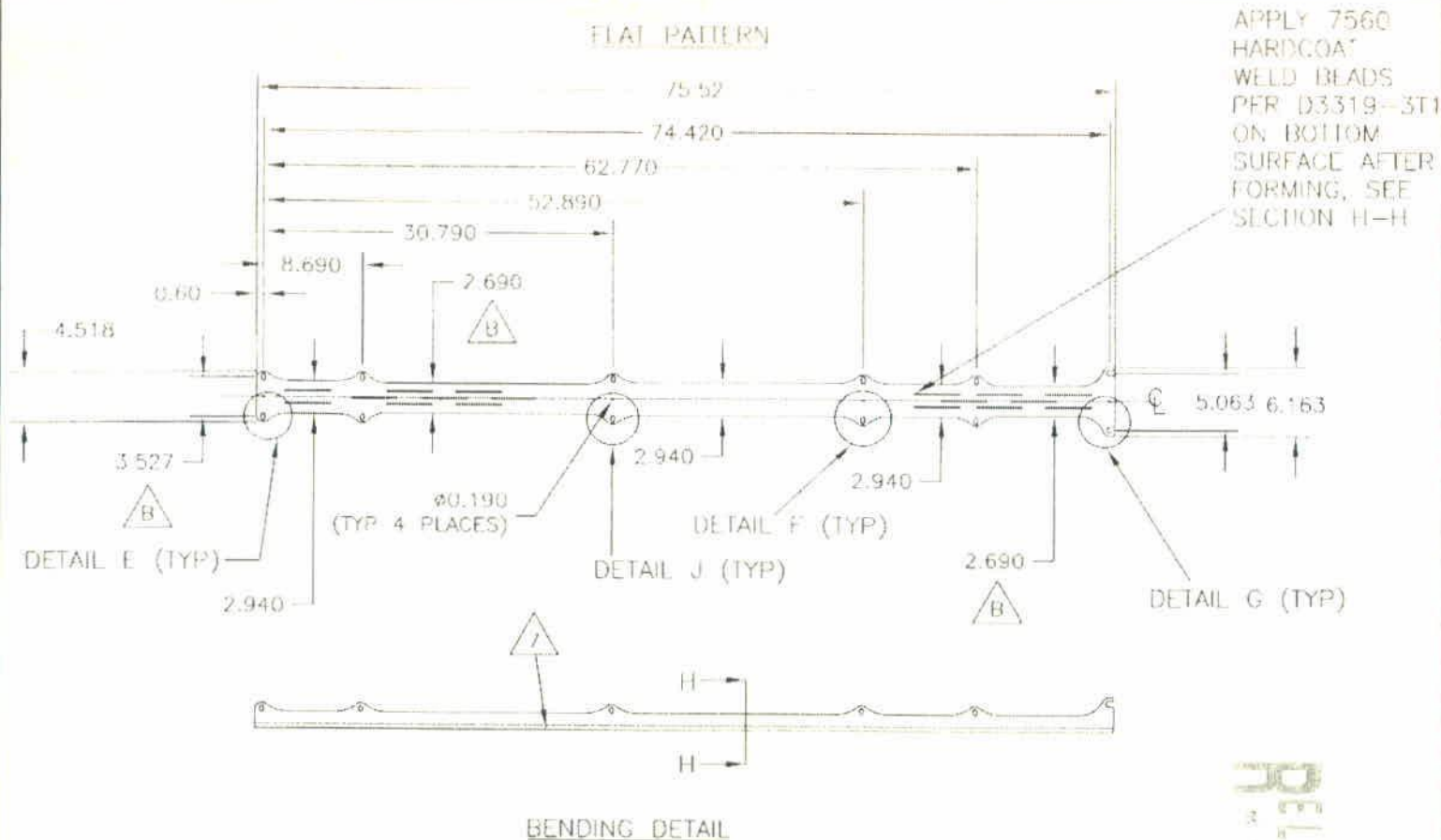
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN	44	DRAWN BY	44	DART AEROSPACE LTD
CHECKED	44	APPROVED	44	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
				SHEET 2 OF 5
				SCALE
				WEARPLATE

RELEASED

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASIM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

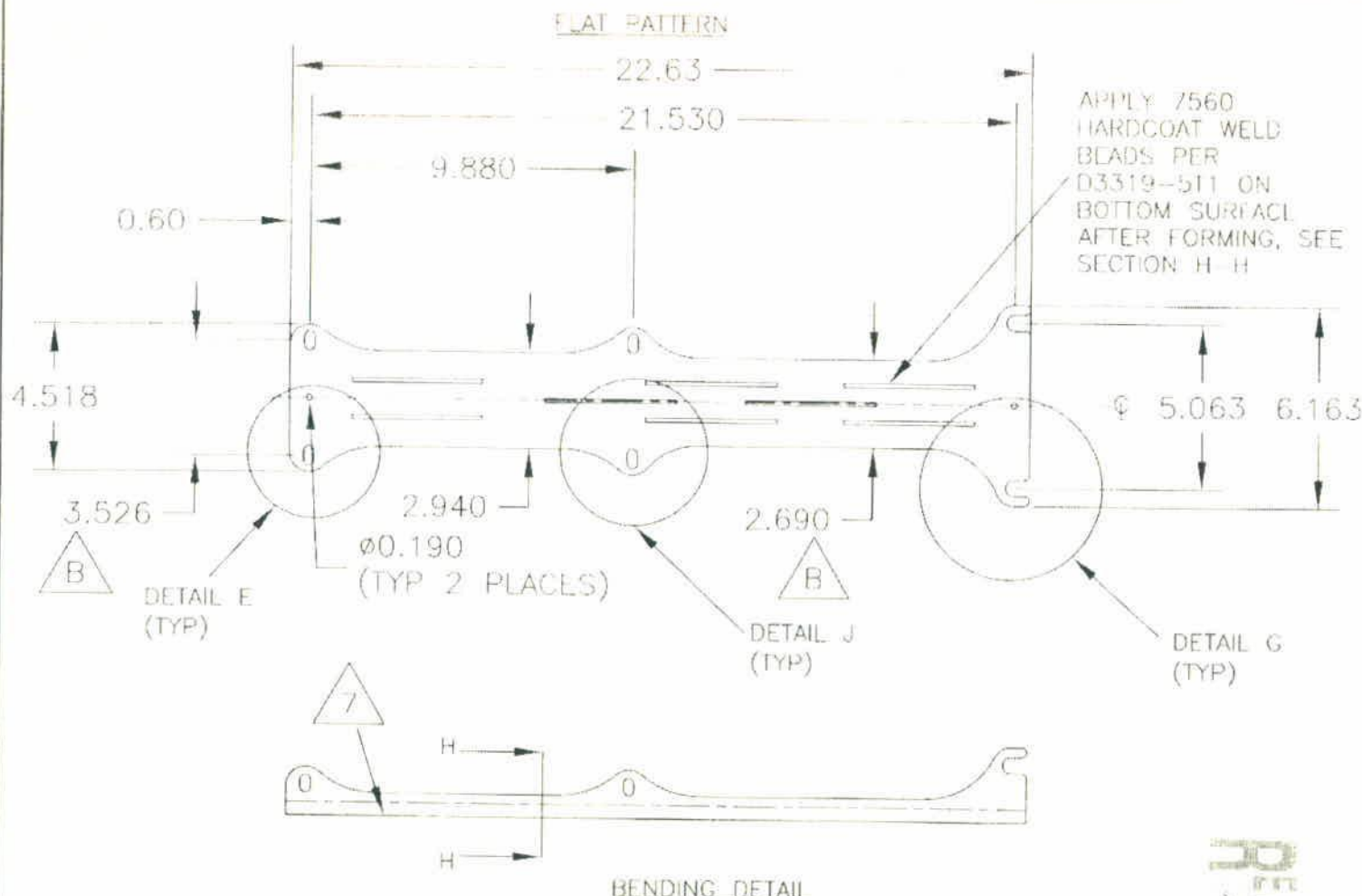
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CHECKED	APPROVED	DRAWING NO	REV B
DATE		33319	SHEET 3 OF 5
05.06.06		TITLE	SCALE
		WEARPLATE	1:5

RELEASED



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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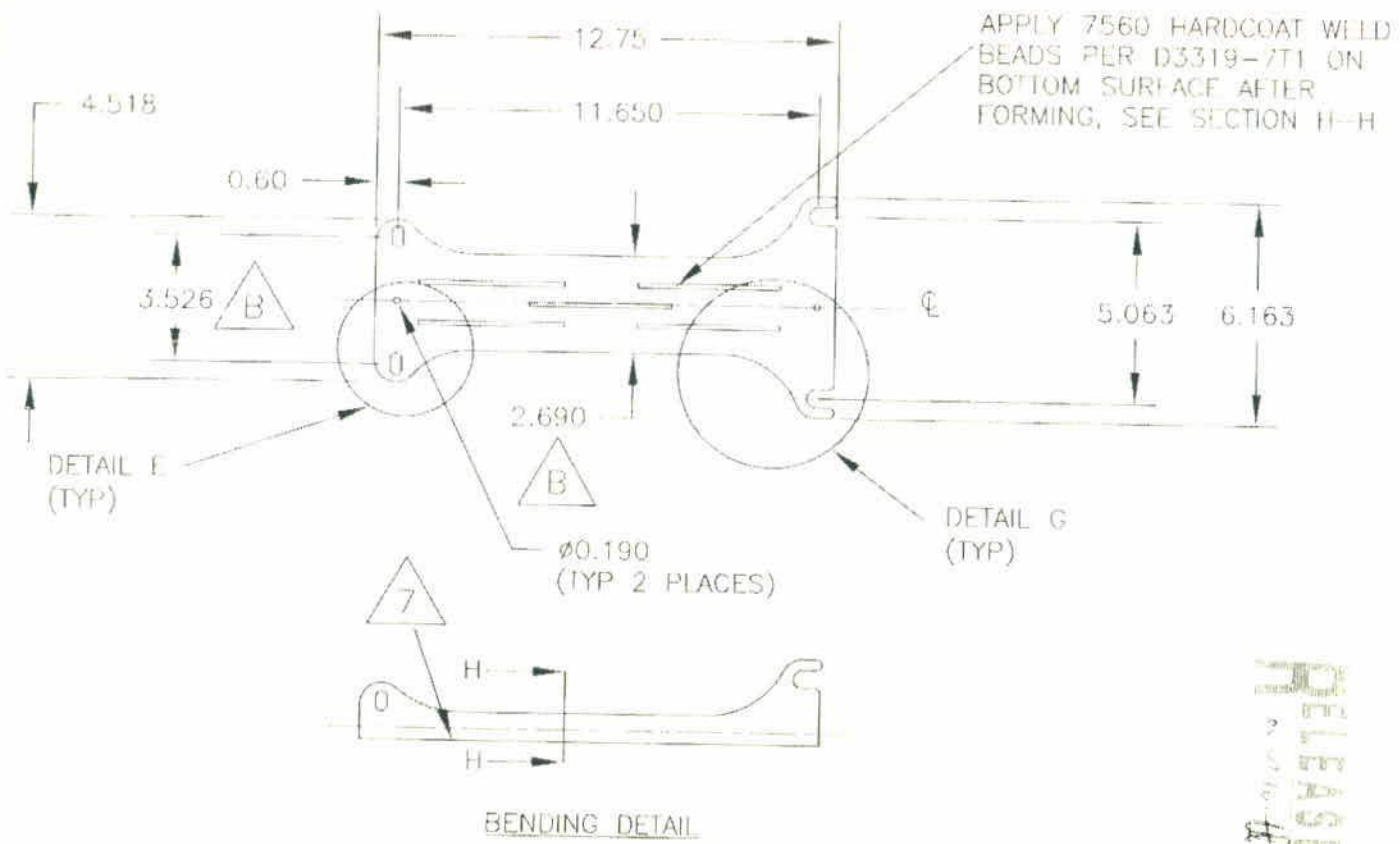
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DESIGN	ft	DRAWN BY	ft	DART AEROSPACE LTD
CHECKED	ft	APPROVED	ft	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
				SCALE 1:5

RELEASED

FLAT PATTERN



BENDING DETAIL

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
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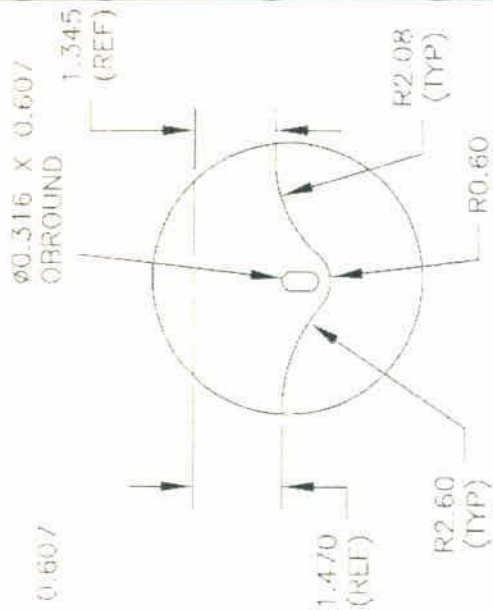
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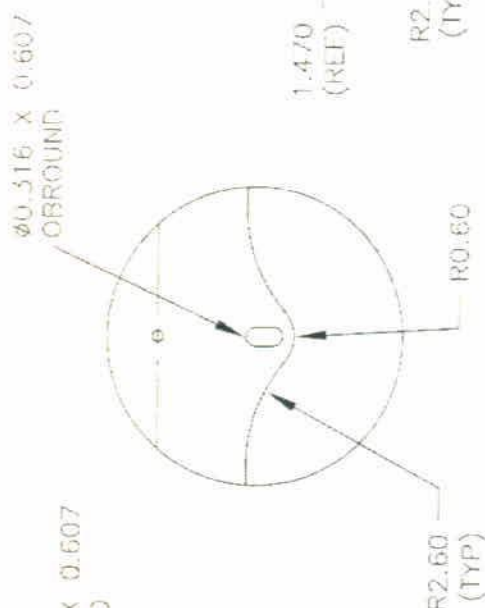


DESIGN HH	DRAWN BY GH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HH	APPROVED GH	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

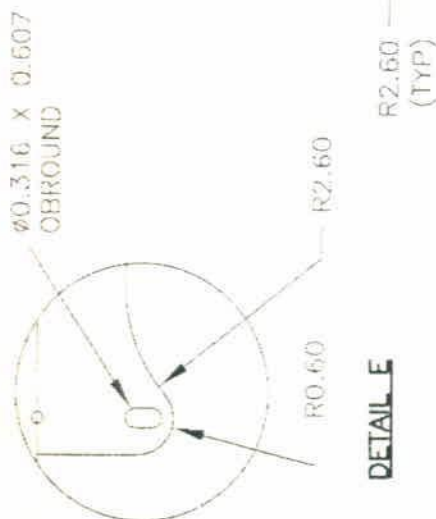
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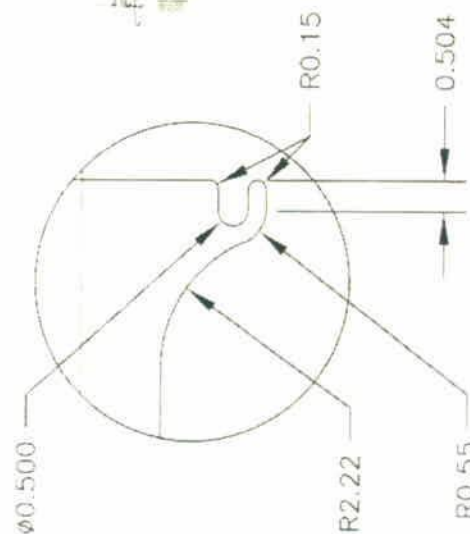
DETAIL J



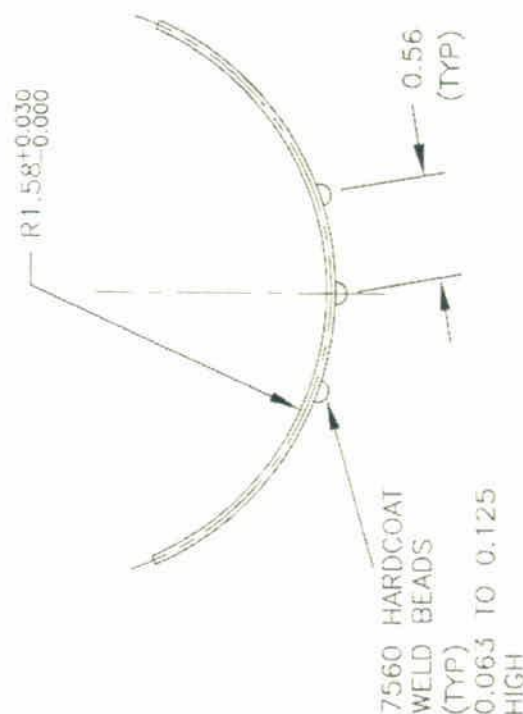
DETAIL F



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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